

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022030**Date Inspected:** 08-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA.**CWI Name:** Ruben Dominguez**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Travelers**Summary of Items Observed:**

This Quality Assurance Inspector Sean Vance arrived on site at Westmont Industries (WMI) in Santa Fe Springs, CA, to randomly observe the in process welding, QC inspection and non-destructive testing of the Travelers.

Upon the arrival of the QA Inspector, the following observations were made:

Traveler Test Rack

This QA Inspector randomly observed WMI production personnel performing fitting, welding and cutting activities on various assemblies for the Traveler Test Rack.

E2/E3-EB Traveler

This QA Inspector, METS representative Mr. Nicolai Hvass and WMI representatives Mr. Cesar Canales and Raymundo Anaya performed random dimensional measuring activities on the E2/E3-EB Traveler. This QA Inspector noted that at this time, most of the welding of the assemblies for the E2/E3-EB Traveler, appeared to be complete. This QA Inspector noted that the above mentioned WMI representatives had previously performed dimensional layout activities, for the E2/E3-EB Traveler. This QA Inspector noted that the layout activities appeared to be square chalk lines on the bay floor and various plumb bobs hanging from key locations on the Traveler assembly. This QA Inspector noted that the above mentioned WMI representatives had previously set up a transit level, for the purpose of verifying the as welded camber. During the activities, this QA Inspector and the above mentioned representatives utilized various lengths of tape measures to perform random dimensional measurements at key locations on the Traveler assembly. During the activities, this QA Inspector noted that these locations included random sections of the various frame assemblies, random sections of the primary and secondary suspension lift plates, random sections of the elevating / platform balconies and random dimensional

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

measurements which appeared to include the overall length, width and height of the completed Traveler assembly. During the activities, this QA Inspector noted that the as welded camber was also verified, utilizing the previously set up transit level.

At approximately 1100, this QA Inspector and the above mentioned representatives had completed the above mentioned random dimensional measurements. Upon completion, this QA Inspector noted that the above mentioned random dimensional measurements appeared to be within +/- 3 mm tolerance on the frame assemblies, lift plates and camber, in relation to the shop drawing measurements. Upon completion, this QA Inspector noted that the above mentioned random dimensional measurements appeared to be within 12 mm tolerance on the overall length of the Traveler, in relation to the shop drawing measurements.

This QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059) continuing to perform Flux Core Arc Welding (FCAW) activities on the E2/E3-EB Traveler assemblies. This QA Inspector observed Mr. Jimenez performing the FCAW in all positions on plate and tube steel material, randomly throughout the shift.

This QA Inspector observed WMI production welder Mr. Eutimo Lopez (WID # 3035) continuing to perform Flux Core Arc Welding (FCAW) activities on the E2/E3-EB Traveler assemblies. This QA Inspector observed Mr. Lopez performing the FCAW in all positions on plate and tube steel material, randomly throughout the shift.

E2/E3-WB Traveler

This QA Inspector observed WMI production welder Mr. Jose Miranda (WID # 3083) continuing to perform Flux Core Arc Welding (FCAW) tacking and fitting activities on the E2/E3-WB Traveler frame assemblies. This QA Inspector observed Mr. Miranda performing the activities on tube steel material, throughout the shift.

This QA Inspector observed WMI production welder Mr. Jose Rodriguez (WID # 3031) continuing to perform Flux Core Arc Welding (FCAW) tacking and fitting activities on the E2/E3-WB Traveler frame assemblies. This QA Inspector observed Mr. Rodriguez performing the activities on tube steel material, throughout the shift.

This QA Inspector observed Smith Emery QC Inspector Ruben Dominguez performing random Magnetic Particle Testing (MT) on the previously completed fillet and flare groove welds, for the E2/E3-WB Traveler frame assemblies.

During observation, this QA Inspector observed that the testing appeared to be in accordance to the approved MT Procedure SE-MT-CT.D1.1-105, Rev. # 1. During observation, this QA Inspector observed that the testing being performed appeared to be random. During observation, Mr. Dominguez explained that he had previously performed Visual Testing on the welds and the welds were acceptable, per AWS D1.1 2002 Visual Acceptance Criteria. Upon completion of the testing, this QA Inspector was then informed by Mr. Dominguez that no rejectable indications were found and that an applicable MT report will be completed.

SAS-WB Traveler

This QA Inspector observed WMI production welder Mr. Daniel Grayum (WID # 3049) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler frame assemblies. This QA Inspector observed Mr. Grayum performing the FCAW in all positions on tube steel and plate material, randomly throughout the shift.

This QA Inspector randomly observed that Smith Emery QC Inspector Mr. Ruben Dominguez was present, during

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

This QA Inspector observed that the activities mentioned above, appeared to be in compliance with the contract requirements and this QA Inspector observed no non-conforming issues, on this date.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Vance,Sean	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer
